



INSTRUCTIONS FOR ALIGNING GROOVES IN ROLL DIES  
AFTER ROLL DIES ARE ASSEMBLED ON ROLL SHAFTS, GROOVES ARE ALIGNED BY CHANGING SHIMS AT "B." ADD SHIMS ( $\frac{1}{8}$ " MAXIMUM) TO MOVE TOP ROLL SHAFT TO THE RIGHT. REMOVE SHIMS ( $\frac{1}{8}$ " MAXIMUM) TO MOVE TOP ROLL SHAFT TO THE LEFT.

ADJUSTMENT FOR WEAR

WHEN SIDE RUNNING CLEARANCE BECOMES EXCESSIVE, THE ROLL SHAFTS CAN BE ADJUSTED AS FOLLOWS:

1) TOP ROLL SHAFT

REMOVE THE NECESSARY THICKNESS OF SHIMS AT "A" TO BRING THE TOTAL SIDE CLEARANCE TO  $\frac{1}{32}$ ".

2) BOTTOM ROLL SHAFT

REMOVE THE NECESSARY THICKNESS OF SHIMS AT "C" TO BRING THE TOTAL SIDE CLEARANCE TO  $\frac{1}{32}$ ". WITH THE ROLL SHAFTS AT THE DESIRED STOP POSITION, AND THE ZERO MARK ON THE ROTARY CAM SWITCH VERTICALLY UP, REASSEMBLE THE CAM SWITCH DRIVING CHAIN.

WHEN ORDERING REPLACEMENTS, STATE SERIAL NUMBER AND SIZE STAMPED ON NAME PLATE OF MACHINE AND DESIGNATE PART BY BOTH NAME AND NUMBER

R 179	TOP ROLL SHAFT	R 266	BEARING BLOCK (R.H.)
R 180	BOTTOM ROLL SHAFT	R 267	BEARING SHIELD RETAINER
R 181	ROLL HOUSING FLANGED BUSH. (R.H.)	R 268	BEARING BLOCK HOLDUP STUD (L.H.)
R 185	TOP ROLL SHAFT GEAR	R 269	ADJUSTING WEDGE (L.H.)
R 186	TOP ROLL ADJUSTING SLEEVE	R 270	BEARING BLOCK (L.H.)
R 187	TOP ROLL ADJ. SLEEVE EYEBOLT	R 271	TOP ROLL SHAFT BUSHING (L.H.)
R 188	TOP ROLL ADJ. SLEEVE POPPET	R 390	TOP ROLL SHAFT ADJ. RETAINER
R 189	TOP ROLL ADJ. SLEEVE EYEBOLT PIN	R 391	TOP ROLL SHAFT END CAP
R 190	TOP ROLL ADJ. SLEEVE STUD & WASHER	R 274	BOTTOM ROLL SHAFT BUSHING
R 191	BOTTOM ROLL SHAFT GEAR	R 275	BOTTOM ROLL SHAFT END CAP & CAM STUD
R 192	BOTTOM ROLL SHAFT SPACER COLLAR	R 276	SHIMS - R.H. COMPLETE SET
R 193	BOTTOM ROLL SHAFT THRUST RING	R 277	SHIMS - L.H. COMPLETE SET
R 199	DIE SLEEVE	R 278	ROLL HOUSING
R 200	DIE SLEEVE RET. PLATE	R 279	DIE KEY
R 264	BEARING BLOCK HOLDUP STUD (R.H.)	R 392	L.H. BEARING BLOCK END PLATE
R 265	ADJUSTING WEDGE (R.H.)	R 393	R.H. BEARING BLOCK END PLATE